

31

Date: Tuesday, 6/26/2007 3:11:02 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE  
Job Number : 33157  
Estimate Number : 10553  
P.O. Number : N/A Part Number : D206667103BL  
This Issue : 6/26/2007 S.O. No. : N/A Drawing Number : D206-667-143 REV B  
Prsht Rev. : NC Project Number : N/A  
First issue : N/A Type : LANDING GEAR Drawing Revision : B  
Previous Run : 33156 Material : N/A  
Due Date : 7/30/2007 Qty: 1 Um: Each  
Written By :  
Checked & Approved By : 07.06.27  
Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell  
Skid tubes KJJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG002

2.0 D6002115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6002-115 Crosstube 629113

Check OD = 2.250"; ID = 1.750"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA087

2-Turn first side as per Folio FA087

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 17 PAR #:  Fault Category:  NCR: Yes No DQA:  Date:

QA: N/C Closed:  Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/25	30	The finition of a part was .009" under of the Tolerance. Tools #2 for finish was not set correctly.	CP 07-0831 per 081042	Replace and destroy REF IS EMAIL	S.F. 07/07/25 JF 07/08/31	Er 07/08/31	UP 07.10.31 per 081042	Sp 07/08/31
		So the cote of 2.176" was 2.167" and the 2.201 was 2.992". The whole tube.	↓					↓

NOTE: Date & initial all entries

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Drawing Name: 206L FWD X-TUBE

Job Number: 33157

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA087

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

*8/07/08/31*  
*2/07/07/29*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*2/07/08/31* / *2/07/07/29*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*7-9-09-17*

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

*7-9-27*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En 7-9-28*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SR 7-9-28*

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

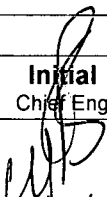
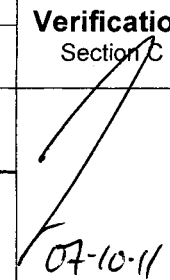
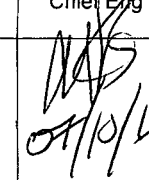
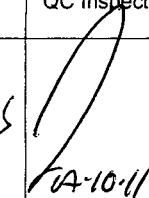
Bend tube as per Dwg D206-667-143 using CNC bender program 206L-fw and Folio FT017

*(PTC)*  
*7-10-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-11	11.0	- Tube is over bent, and un-even (see clim sheet) - R.C: Older Program run, and to be over bent between program 3 & 4. Machine error	 07/10/11	- create to update programs - Donate tube to eng. dept, to unbend tube & test for cracks & strength.	E2 7-10-11 E2 7-10-11	 07-10-11	 07/10/11	 07-10-11

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Drawing Name: 206L FWD X-TUBE

Job Number: 33157

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8541 & DT8542 as per Dwg D206-667-143

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-143.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 33157

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: \_\_\_\_\_ LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube DELFLEET BLUE

3-CLEAR WITH DELFLEET

ISSUE P.O TO ATELIER DEBOSSSELAGE \_\_\_\_\_

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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## Process Sheet

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Drawing Name: 206L FWD X-TUBE

Job Number: 33157

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

24.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate

25.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support

26.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

27.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp

28.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L FWD X-TUBE

Job Number: 33157

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

32.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: \_\_\_\_\_

33.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt \_\_\_\_\_

34.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 6/26/2007 3:11:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 33157

Part Number: D206667103BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*Handwritten signature/initials*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 33157
<b>Description:</b> Crosstube Assembly (206L High Fwd)	<b>Part Number:</b> D206-667-143
<b>Inspection Dwg:</b> D206-667-143 Rev: B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245				
	1.982	+0.005/-0.000	1.987				
	2.019	+0.005/-0.000	2.024				
	2.058	+0.005/-0.000	2.063				
	2.097	+0.005/-0.000	2.102				
	2.136	+0.005/-0.000	2.141				
	2.176	+0.005/-0.000	2.181				
	2.201	+0.005/-0.000	2.206				
	0.125	+/-0.010	.125				
	0.400 x 30°	+/-0.010	.400				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.438				
SIDE B	104.98	+/-0.020	104.980				
	2.240	+0.005/-0.000	2.245				
	1.982	+0.005/-0.000	1.987				
	2.019	+0.005/-0.000	2.024				
	2.058	+0.005/-0.000	2.063				
	2.097	+0.005/-0.000	2.102				
	2.136	+0.005/-0.000	2.141				
	2.176	+0.005/-0.000	2.181				
	2.201	+0.005/-0.000	2.206				
	0.125	+/-0.010	.125				
	0.400 x 30°	+/-0.010	.400				
	R0.063	+/-0.010	.063				
	R0.500	+/-0.010	.500				
	4.438	+/-0.030	4.438				

<b>Measured by:</b> JB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/08/2011	<b>Date:</b> 07-09-17	<b>Date:</b>	N/A

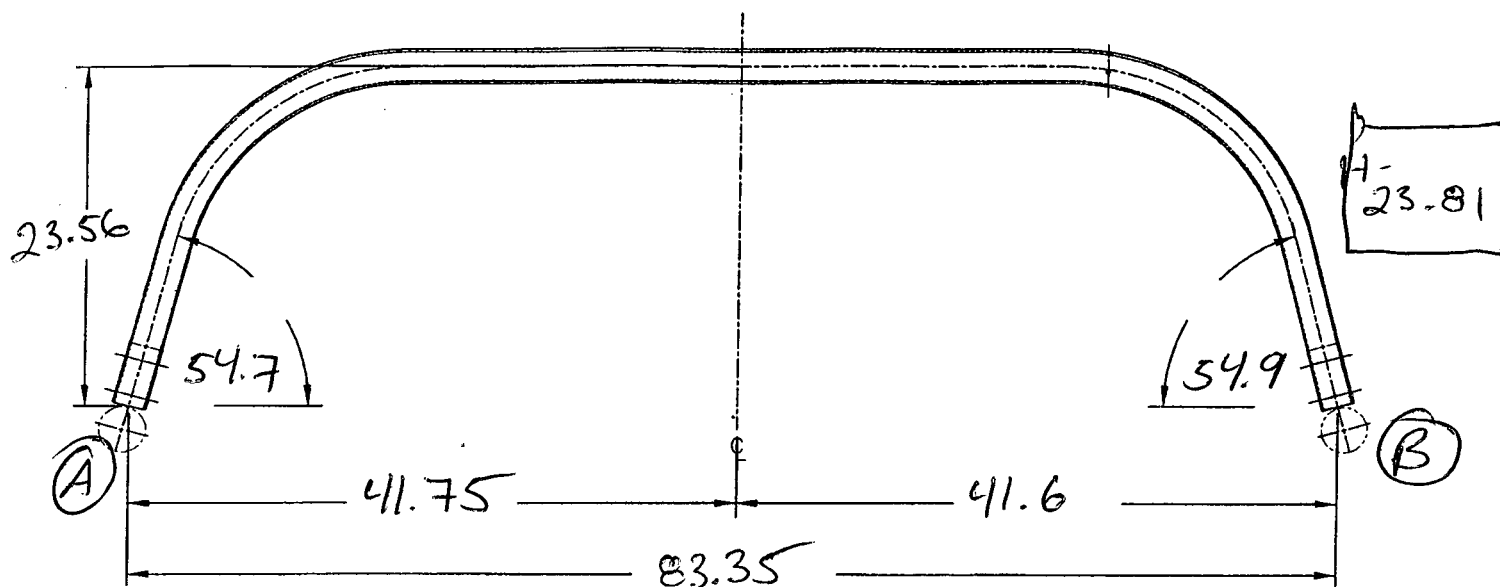
Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	[Signature]





DART AEROSPACE LTD		Work Order:	33157
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96

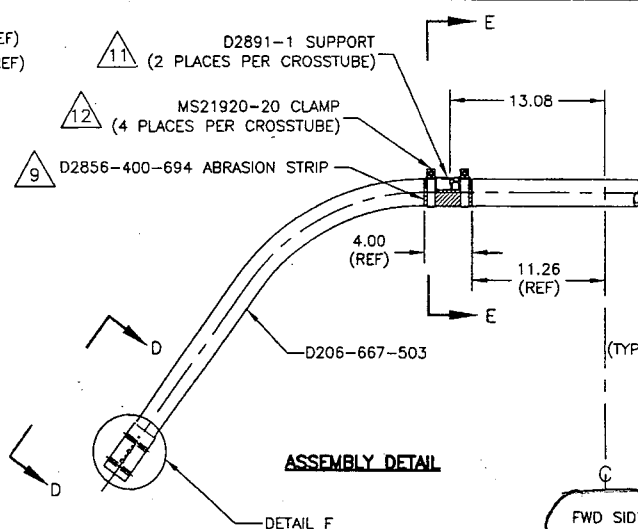
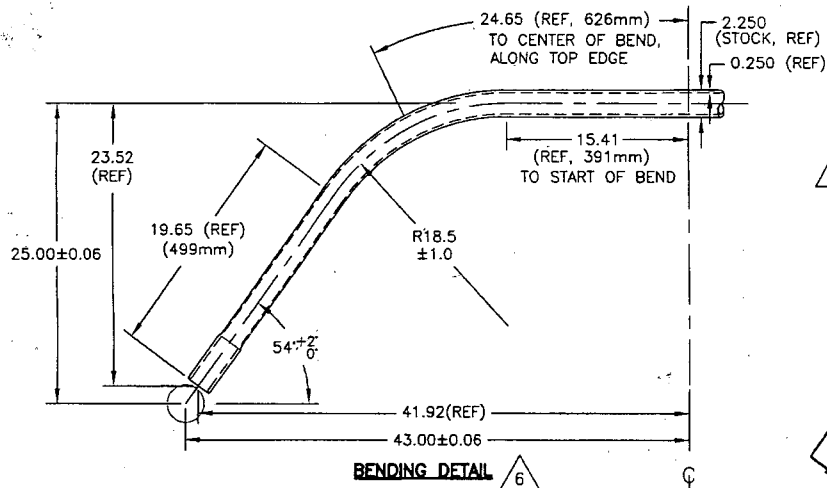


Comments
Tube is very un-even, over bent, and does not sit well on the table jig.
<del>Scrap</del>

QC15 Inspection	<i>[Signature]</i>
Date	12-10-11

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>





B  $\phi 0.323^{+0.005}_{-0.000}$   
(TYP 5 PLACES PER CUFF)  
HOLE TO BE ALIGNED WITHIN  $\pm 0.001$   
OF HOLE ON OTHER SIDE OF CUFF

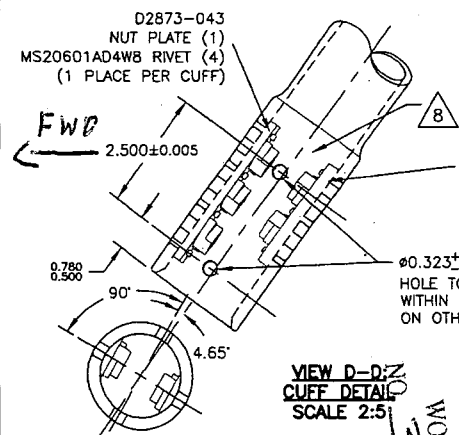
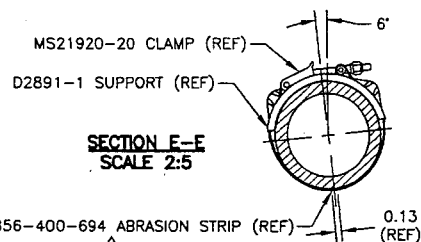
PILOT  $\phi 0.128$   
C'SINK  $\phi 0.225 \times 100'$   
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

**DETAIL E**  
SCALE 2:5

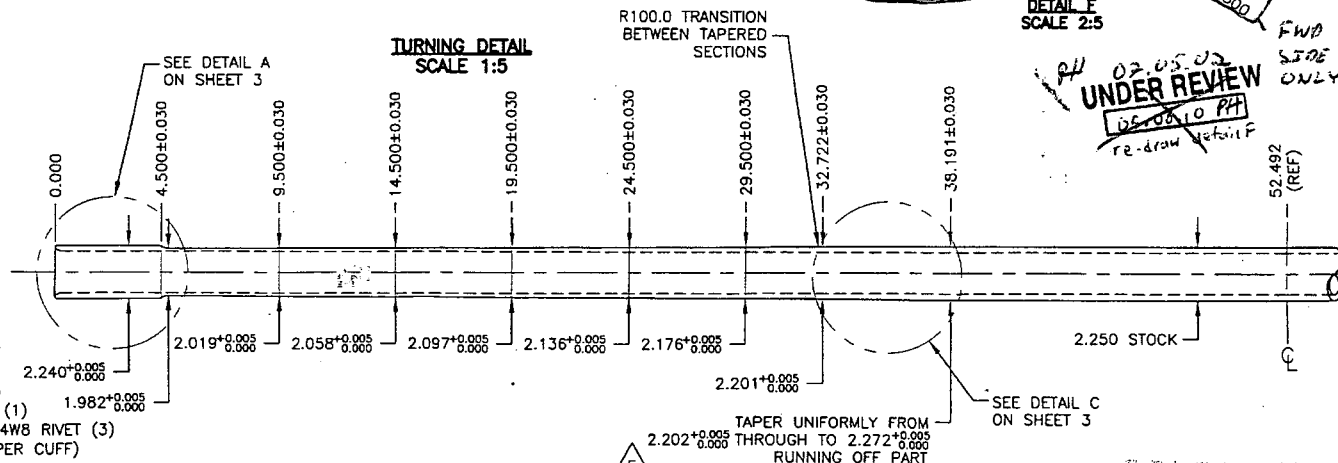
PH 02.05.02  
**UNDER REVIEW**  
DS 05.10 PH  
re-draw Detail F

FWD  
SIDE  
ONLY



SHOOT COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
33157

**TURNING DETAIL**  
SCALE 1:5

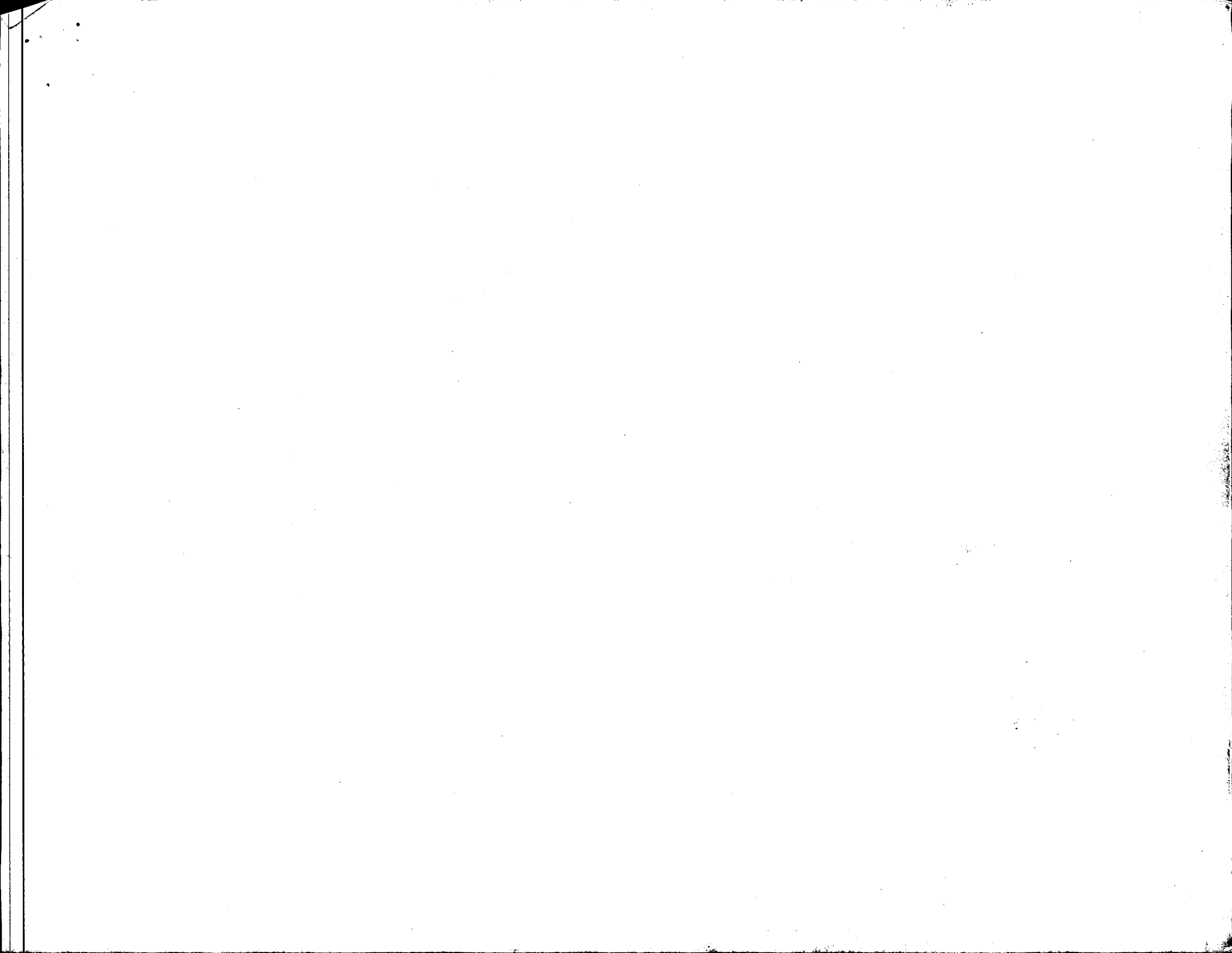


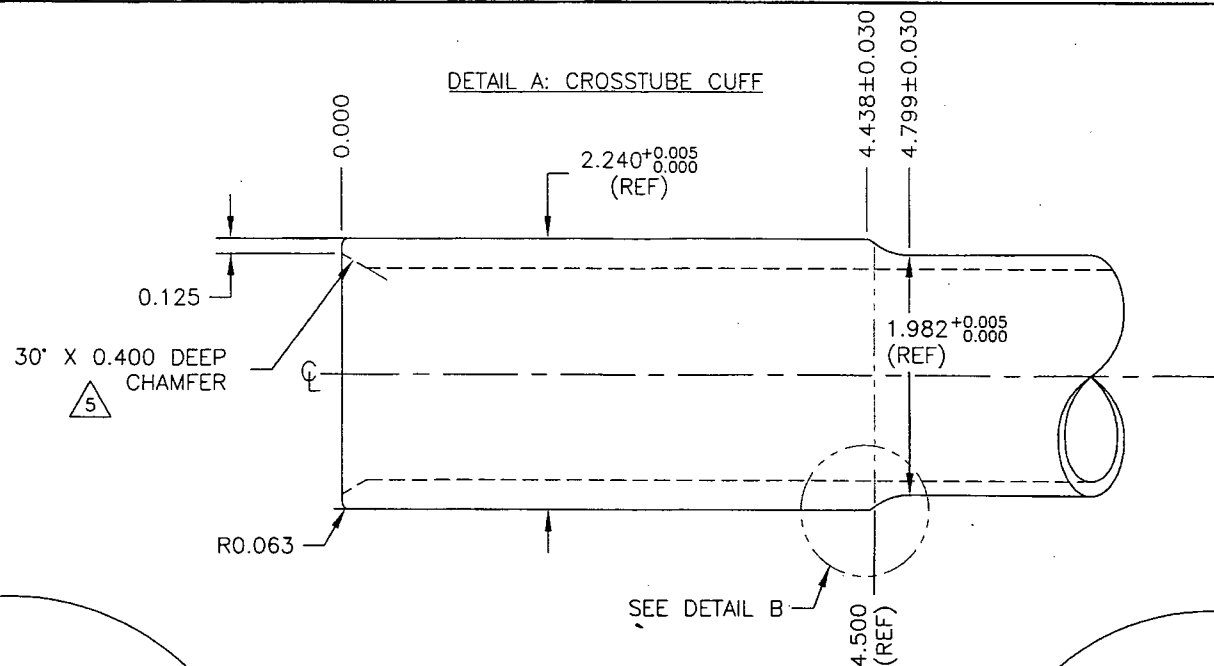
SEE DETAIL C  
ON SHEET 3

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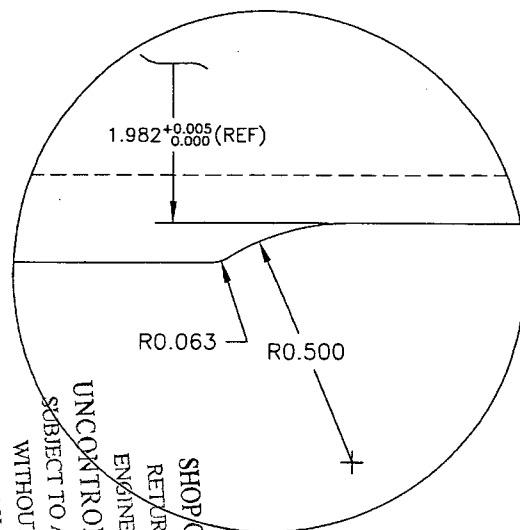
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DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	REV. B
CHECKED DS	APPROVED DS	DRAWING NO. D206-667-143	SHEET 2 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:10	



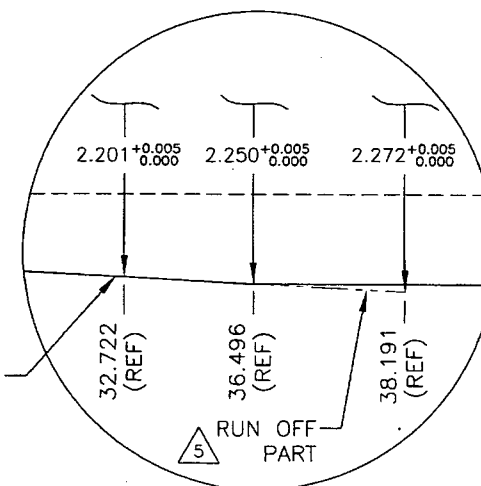


UNDER REVIEW  
 06.05.02 PH  
 re-draw detail F  
 PH 07.05.02



DETAIL B: CUFF  
 TRANSITION  
 SCALE 4:1

DETAIL C:  
 TAPER RUN-OFF  
 NOT TO SCALE



NO. 3357  
 WORK ORDER  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
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 RETURN TO  
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DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
DATE	05.07.26			D206-667-143	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (206L HIGH FWD)	1:1



## Chris Provencal

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** August 31, 2007 11:17 AM  
**To:** 'Chris Provencal'  
**Subject:** RE: NCR D206-667-103

Agree. Scrap it.

David

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**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Thursday, August 30, 2007 10:55 AM  
**To:** '\*David Shepherd (\*David Shepherd)'  
**Subject:** NCR D206-667-103

David,

They have a D206-667-103 crosstube with one side under tolerance on the OD by 0.009" along the entire length, ie. the cuff and all along the taper. The tool wasn't set correctly. Eric and I both think we should probably scrap it. It'd be basically using up a large amount of the allowable damage tolerance along the entire length of the tube.

-Chris

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.5.484 / Virus Database: 269.12.12/979 - Release Date: 8/29/2007 8:21 PM

No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.5.484 / Virus Database: 269.12.12/979 - Release Date: 8/29/2007 8:21 PM

31/08/2007

